

Work Order ID 73591-2

Tuesday, September 06, 2011 11:12:38 AM

Page 1

Item ID: D3436-043

Revision ID:

Item Name: Step 1.11

Start Date: 9/6/2011

Required Date: 9/9/2011

Reference:

Start Qty: 2.00

Req'd Qty: 2.00

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date: 11-07-06

Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Draw Nbr

D3436

100



Large Fab

Large Fab

Operation
Description

Revision Nbr

Rev A

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

Memo

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436 Dwg Rev A Qty 1 Part Number DT8772 Description Weld
Batch A/RN/A 4130 Welding Rod M100075
left step D3436-7 using welding Jig DT

0.00

BAND SAW

0.00

Memo

1- Slit part D3436-041 on bandsaw as per Dwg D3436
deburr

0.00

QC 9- Inspect visual per QS1004- Fusion Welds

0.00

Memo

120



QC

Quality Control

CL 11-9-8 (22)

CL 11-9-8 (22)

2.2 0 2010/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 73591

Tuesday, September 06, 2011 11:12:38 AM

Page 2

Item ID: D3436-043

Revision ID:

Item Name: Step L.H

Start Date: 9/6/2011 Start Qty: 2.00

Required Date: 9/9/2011 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 u/09/08

42
47

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Wing Walk batch:

1133/3

PR 11-9-12(2)

2x 6 ml 11/09/12

LH

26H 6 ml u/09/12

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

M 117745

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 73591

Tuesday, September 06, 2011 11:12:38 AM



Page 3

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 9/6/2011 Start Qty: 2.00



Required Date: 9/9/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

155

0.00



Small Fab

Memo

0.00

Small Fab

Bond D3436-9 pads as per dwg and QSI 015

Handwritten signature and date 9/6/07/12 with circled 1

169

0.00



QC

QC5- Inspect part completeness to step on W/C

Memo

0.00

Quality Control

Handwritten signature and date 9/6/12

Handwritten circled signature with 'H' and 'LH'

170

0.00



Packaging

Identify as per dwg & Stock Location: *198A*

Memo

0.00

Packaging

Handwritten signature and date 11/9/12 with circled 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 73591

Tuesday, September 06, 2011 11:12:38 AM



Page 4

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Step L11

Start Date: 9/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/13

mf

11-09-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 06, 2011 11:12:34 AM

Page 1

Work Order ID: 73591

Parent Item: D3436-043

Parent Item Name: Step L.H



Start Date: 9/6/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A 05.05.11 New Issue KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|---------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D3436-1 | | Manufactured | No | | | 100 | Each | 41.0000 | 1 | 2 | | | |
|---------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|



Clamp



EL 10-9-7

Location

Loc Qty

Loc Code

WA021

41

17679

41

D3436-3

| | |
|--------------|----|
| Manufactured | No |
|--------------|----|

100

Each

0.0000

1

2



Left Step

D3436-5

| | |
|--------------|----|
| Manufactured | No |
|--------------|----|

100

Each

20.0000

4

8



Bushing



EL 10-9-7

Location

Loc Qty

Loc Code

ST

20

46592

20

D3436-7

| | |
|--------------|----|
| Manufactured | No |
|--------------|----|

160

Each

43.0000

1

2



Cap



EL 10-9-7

Location

Loc Qty

Loc Code

WA021

43

56836

43

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 06, 2011 11:12:35 AM

Page 2

Work Order ID: 73591

Parent Item: D3436-043

Parent Item Name: Step L11



Start Date: 9/6/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

123436-9

Manufactured No

100 Each

12.0000

2 4



Pad



SO 11/29/12

Location

Loc Qty

Loc Code

GA

8

56830

2

69599

6

ST053

4

66567

4

B-73469

2

+

Tuesday, September 06, 2011 11:12:35 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

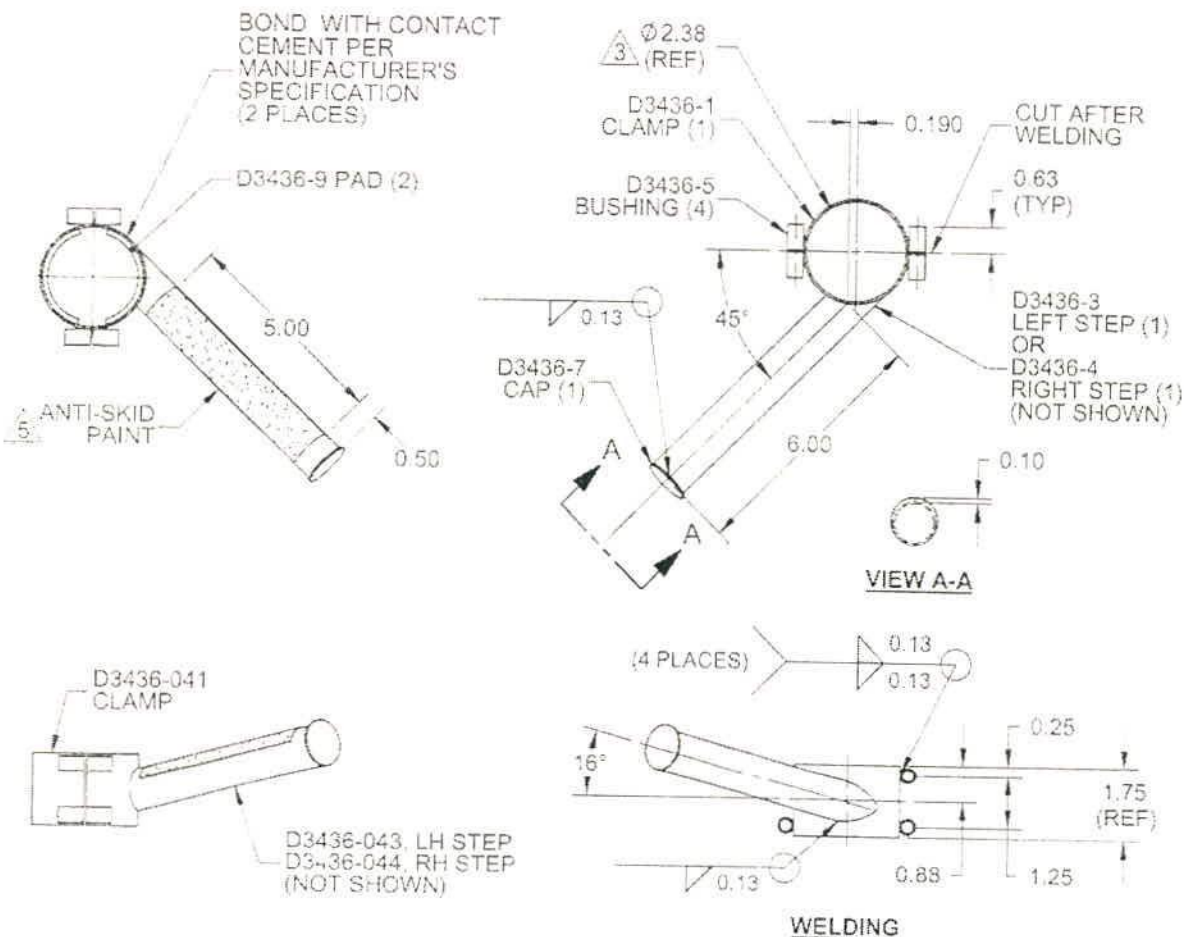
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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|-------------------|--------------------|---|--------------|
| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>MB</i> | APPROVED <i>MB</i> | DRAWING NO. D3436 | REV. A |
| DATE 05.04.28 | | TITLE MAINTENANCE STEP | SHEET 1 OF 4 |
| A | 05.04.28 | NEW ISSUE | SCALE 1:4 |



NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

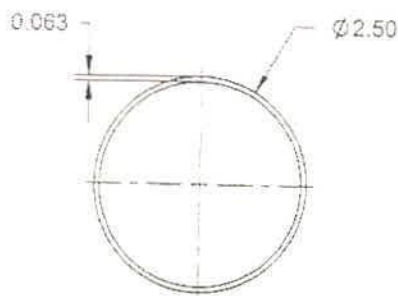
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NOTE: Date & initial all entries

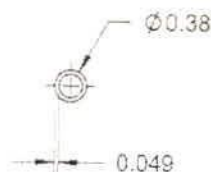


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| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED  | APPROVED  | DRAWING NO. D3436 | REV. A |
| DATE 05.04.28 | TITLE MAINTENANCE STEP | | SHEET 2 OF 4 |
| | | | SCALE 1:2 |



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

05-05-27 *[Signature]*

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

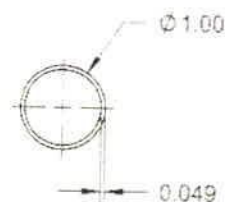
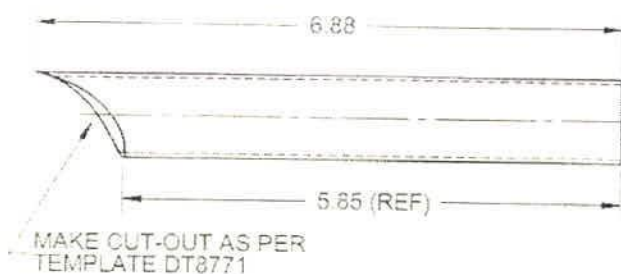
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



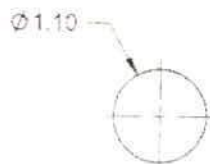
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| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED  | APPROVED  | DRAWING NO. D3436 | REV. A |
| DATE 05.04.28 | | TITLE MAINTENANCE STEP | SHEET 3 OF 4 |
| | | | SCALE 1:2 |



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6738, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
05-05-27

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

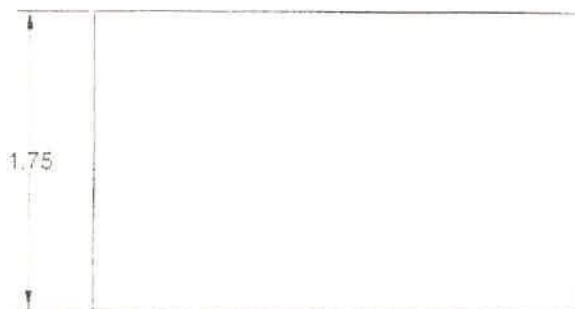
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NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|---|------------------------|
| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3436 | REV. A SHEET 4 OF 4 |
| DATE 05.04.28 | | TITLE MAINTENANCE STEP | SCALE 1:1 |



D3436-9 PAD

NOTES:

- 1) MATERIAL 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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